

Date: Tuesday, 13/05/2008 9:28:05 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LITTER TIE DOWN ASSY	
Job Number	: 39221		Part Number	: D2350	
Estimate Number	: 10360		Drawing Number	: D2350 / D2363	
P.O. Number	:		Project Number	: N/A	
This Issue	: 13/05/2008 S.O. No. :		Drawing Revision	: B/E <i>1008/05/13</i>	
Prsht Rev.	: NC		Material	:	
First Issue	: // Type : MACHINED PARTS		Due Date	: 18/06/2086 Qty: 6 Um: Each	
Previous Run	: 36696				
Written By	:				
Checked & Approved By	<u>JUL 08.5.13</u>				
Comment	: est rev B 06.05.17 added ass'y EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	D6201	"T" Extrusion
		Comment: Qty.: 1.0631 f(s)/Unit Total : 6.3788 f(s) Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion <i>B36793</i> Batch: <i>mk 08/05/20</i> (1)
2.0	BAND SAW	BAND SAW
		Comment: BAND SAW Cut blanks: 12.150" long <i>mk 08/05/20</i> (2)
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio D2363 and Dwg D2363 <i>mk 08/05/20</i> (3)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>mk 08/05/20</i> (4)
5.0	QC8	SECOND CHECK
		Comment: SECOND CHECK <i>mk 08/05/21 (46)</i>
6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Tumble & deburr <i>mk 08/05/21</i> (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 2350 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/06/04
 QA: N/C Closed: _____ Date: _____

NCR: 39221		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/21	3	MAT'L UNDER SIZED. DIM 1.70" IS 1.65" DIM 4.00(CREF) IS 3.957	GP 08/05/21 per QSI 042	PART OK. REF DS EMAIL	WL 08/05/21	(GP 08/05/21 per QSI 042	(

NOTE: Date & initial all entries

Date: Tuesday, 13/05/2008 9:28:06 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 39221

Part Number: D2350

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC5

INSPECT WORK TO CURRENT STEP



S 08/05/21 (46)

Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(6)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 08-05-21

9.0 POWDER COATING

POWDER COATING



(6x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 10:00

00°F

OVEN TEMPERATURE: 320

00

FINISH TIME: 10:00

M/L 08/05/22

(6)

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0 D2372

Quick Release



(6)

Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Assembly Kit

-6

Qty Part Number Description Batch

2 D2372

Fastener

37448

B39452

E/S.

(1)

3P

(6)

12.0 D2444

Pip Pin Assembly



(6)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2444

Pip Pin

38101

38295

2X

5P

13.0 AN960JD10L

Washer



(6x)

Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

3 AN960JD10L

Washer

104885

8/5/23

5P

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 13/05/2008 9:28:06 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASSY

Job Number: 39221

Part Number: D2350

Job Number:



Seq. #: Machine Or Operation:

Description :

14.0 MS21042L3 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS21042L3 Nut (or -3) 107644

SP

15.0 MS27039113 Screw



(6x)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

X Qty Part Number Description Batch
1 MS27039-1-13 Screw 13719

8/3/23

SP

16.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2350

8/08/06/03 (6)

17.0 QC5 INSPECT WORK TO CURRENT STEP



8/08/06/03 (46)

Comment: INSPECT WORK TO CURRENT STEP

18.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST185

8/08/06/03 (6)

19.0 QC21 FINAL INSPECTION/W/O RELEASE



08/06/04 (6)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

33922

DART AEROSPACE LTD	Work Order:	B09-2021
Description: Litter Tie Down Bracket	Part Number:	D2363
Inspection Dwg: D2363	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

26

157

Prototype Approval: N/A

Date: 08/05/20

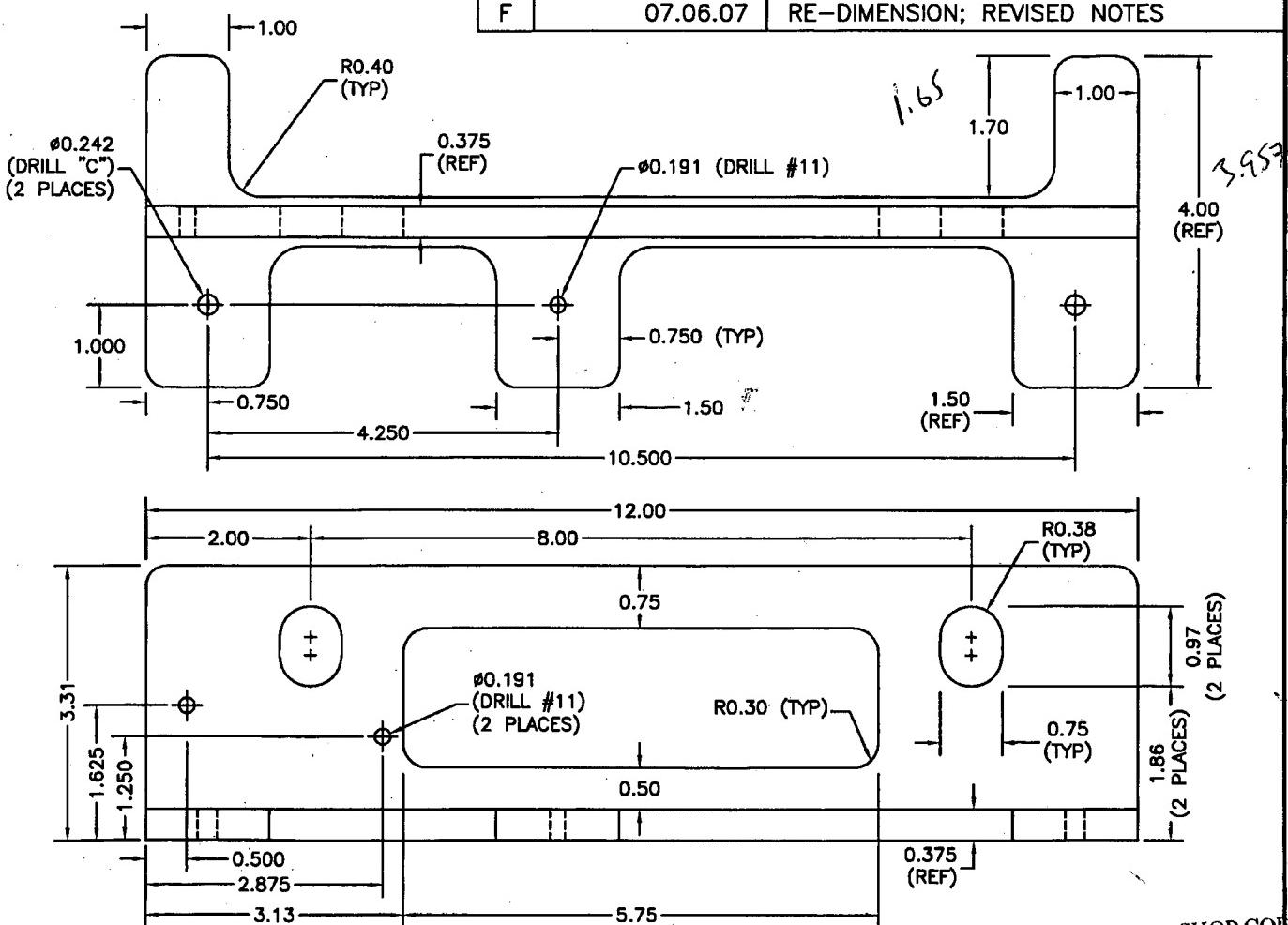
Date: 28/05/2022

Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.11.22	New Issue P/O D2350	KJ/JLM	
B	07.07.17	Dimensions updated per Dwg Rev. F	KJ/JLM	EE

DART

DESIGN BW	DRAWN BY <i>JL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AS</i>	APPROVED <i>HT</i>	DRAWING NO. D2363	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER TIE DOWN BRACKET	SCALE 1:2
A	95.01.14	NEW ISSUE	
B	95.02.14	MODIFIED HOLES	
C	95.03.06	0.191 WAS 0.197	
D	95.03.06	CHANGES TO DIMENSIONS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	RE-DIMENSION; REVISED NOTES	



D2363 LITTER TIE DOWN BRACKET

- 1) MATERIAL: MAKE FROM D6201-012 EXTRUSION (6061-T6/T651 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2363" USING FINE POINT PERMANENT INK MARKER

RELEASED

07.06.07



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WORK ORDER

NO. 37221

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DART

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>JF</i>	DRAWING NO. D2350	REV. B SHEET 1 OF 2
DATE 95:02:20	TITLE LITTER TIE DOWN ASSEMBLY		SCALE

RELEASED
960607

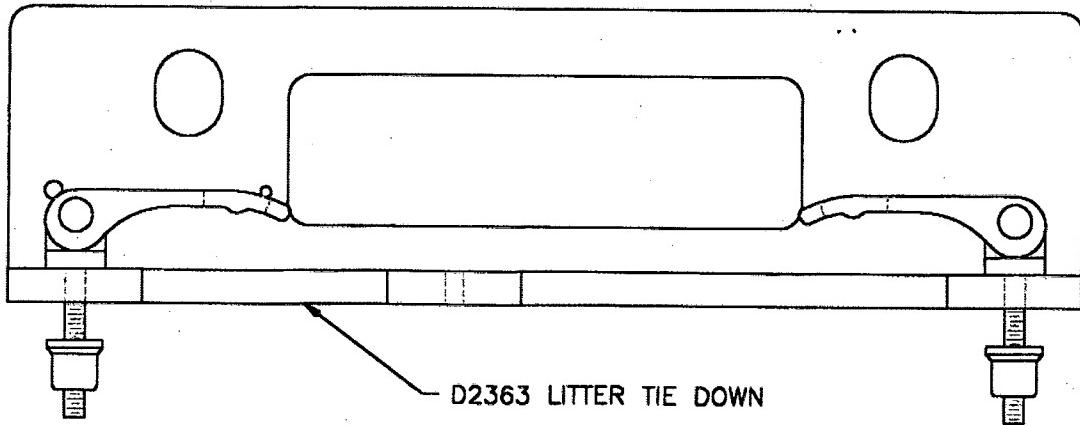
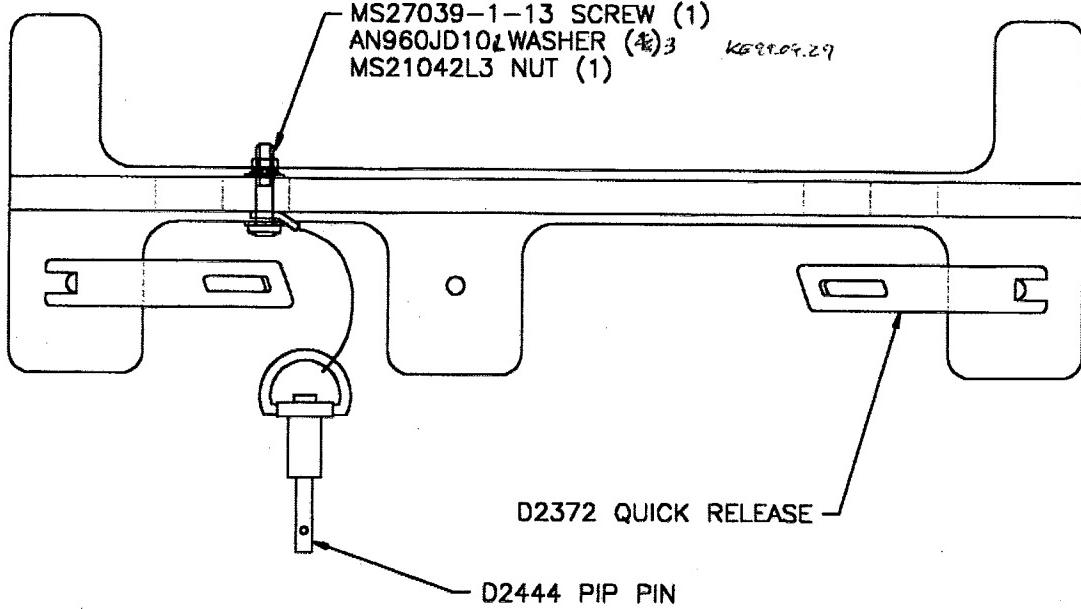
D2350	Part No.	Description
X	D2350	LITTER TIE DOWN ASSEMBLY (NON-LOCKING)
1	D2363	LITTER TIE DOWN (NON-LOCKING)
2	D2372	QUICK RELEASE FASTENER
1	D2444	PIP PIN
<i>X 3</i>	AD960JD10 L	WASHER
1	MS21042LB	NUT
1	MS27039-A-13	SCREW

KE 99.04.29

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DART

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CHECKED <i>PW</i>	APPROVED <i>SJ</i>	DRAWING NO. D2350	REV. B SHEET 2 OF 2
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY	SCALE

RELEASED
96 06 07

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WORK ORDER
NO. _____

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: May 20, 2008 3:11 PM
To: 'Chris Provencal'
Cc: 'Mike Petsche (E-mail)'
Subject: RE: NCR D2363 Litter Tie Down

Chris,

I agree. These parts are acceptable.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Tuesday, May 20, 2008 11:13 AM
To: 'David Shepherd'
Cc: 'Mike Petsche'
Subject: NCR D2363 Litter Tie Down

David,

D2363 Litter Tie Down Bracket. Dim 1.70" is 1.65", 4.00" (ref) is 3.957", see attached pic. The stock material was undersized. I don't see a problem with this.

-Chris

No virus found in this incoming message.

Checked by AVG.

Version: 7.5.524 / Virus Database: 269.23.21/1456 - Release Date: 5/20/2008 6:45 AM

No virus found in this outgoing message.

Checked by AVG.

Version: 7.5.524 / Virus Database: 269.23.21/1456 - Release Date: 5/20/2008 6:45 AM